Monday, 11/12/2007 11:46:32 AM Date: Kim Johnston User **Process Sheet** : BUSHING **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 35633 : 11148 **Estimate Number** : D32093 Part Number P.O. Number Alh: · D3209 REV A : 11/12/2007 **Drawing Number** This Issue .; N/A Project Number Prsht Rev. : MACHINED PARTS **Drawing Revision** Type First Issue : 29907 Material Previous Run 11/30/2007 Each Due Date Qty: Written By Checked & Approved By : Est New issue KJ/RF Comment **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 303 Round Bar 0.500" M303R0500 Comment: Qty.: 0.6993 f(s) 0.0350 f(s)/Unit Total: Delrin Round Bar .50" black Material: AISI 303 SS Ø0.50" (M303R0.500) Batch: M 106292 Identify for D3209-3 2.0 HARDINGE Comment: HARDINGE CNC LATHE SMALL Turn D3209-3 bushing as per Folio FA354 and Dwg D3209 QC2 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 Comment: SECOND PACKAGING 1 PACKAGING RESOURCE #1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROC	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
· · · · · · · · · · · · · · · · · · ·						/			
Part No):	PAR #:	_ Fault Category:	NCR: Ye	es No DQ	A: <u> </u>	Date: ₫	3/11/08	
	•				: N/C Close				

NCR: WORK ORDER NON-CONFORMANCE (NCR)						,	
	Description of NC		Corrective Action Section B				
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
						•-	
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Corrective Action Section B Verification Section C Chief Eng Ch

NOTE: Date & initial all entries

Date:

Monday, 11/12/2007 11:46:33 AM

Uşer:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 35633

Part Number: D32093

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W9:11.29

Dart Ae	rospace	Ltd							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
•									
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQA :		Date:	
					QA: N	C Closed:		Date:	
NCR:		V	WORK ORDE	R NON-CONFORMA	ANCE (NCR)			
	T	Description of NC		Corrective Action Section	ion B	Verifica	tion	Annaval	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	Approval QC Inspector
	,								
					1]		

Chief Eng Date

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35633
Description: Bushing	Part Number:	D3209-3
Inspection Dwg: D3209 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing		Actual	A	Deiest	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.063	+/-0.010	,067 ,237 .023×36°				
0.233	+/-0.010	,232				
0.030 x 30°	+/-0.010	.023×30°				
Ø0.500	+0.010/-0.010	-501				
Ø0.376	+0.001/-0.000	,3765				
Ø0.257	+0.006/-0.001	,3765				
		, , , , , , , , , , , , , , , , , , ,				
				-		
						

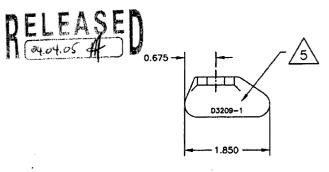
Measured by:	Audited by:	J.F.	Prototype Approval:	N/A
Date: 07/11/28	Date:	07/11/28	Date:	N/A

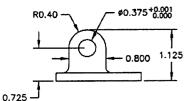
Rev	Date	Chánge	Revised by	Approved
Α	04.12.07	New Issue	KJ/JLM	
В	07.01.16	Tolerance for Ø0.500 revised	JLM/EC	



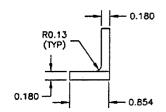


C	ESIGN	DRAWN BY	DART AEROSF HAWKESBURY, ONTAR	
7	HECKĘD	APPROVED.	DRAWING NO.	REV. A
	#	#F	D3209	SHEET 1 OF 1
10	ATE		TITLE	SCALE
	04.01.27		BRACKET	1:2
	A	04.01.27	NEW ISSUE	



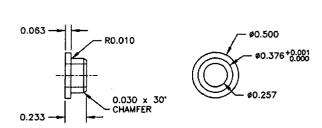


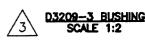


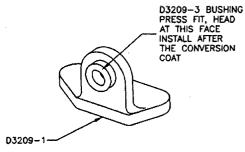




D3209-1 BRACKET









D3209-041 ASSEMBLY

D3209-1 BRACKET: D3209-3 BUSHING
1) BREAK ALL SHARP EDGES 0.005 TO 0.015
2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

ALUMINUM BAR (M6061T6B) 3) MATERIAL: AISI 303 SS (M303R)
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 SUBJECT TO AMENDMENT E DART P/N AS SHOWN 5) ENGRAVE DART P/N AS SHOWN
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) ALL DIMENSIONS ARE INCHES

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

WORK ORDER

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